

What is claimed is:

1. A decorative sheet or a molding, in particular for indoor or outdoor applications on buildings, made from a monolaterally or bilaterally decorative-layer-laminated, pressed single- or multilap core layer made from wood fibers, cellulose fibers, a mixture of wood fibers and cellulose fibers, or from timber sawdust products, wherein the fibers or the timber sawdust products have been impregnated with a resin as binder and are surrounded by the hot-curing binder, wherein the core layer comprises a filler material whose particle size is smaller than the thickness of the fibers or of the timber sawdust products.

2. The decorative sheet or the molding as claimed in claim 1, wherein the core layer is composed of from 15 to 80% by weight of fibers or of timber sawdust products, from 10 to 75% by weight of filler material, and from 10 to 50% by weight of resin, based in each case on the total weight of the core layer.

3. The decorative sheet or the molding as claimed in claim 1, wherein the core layer encompasses from 25 to 75% by weight of fibers or of timber sawdust products, from 20 to 50% by weight of filler material, and from 15 to 35% by weight of resin, based in each case on the total weight of the core layer.

4. The decorative sheet or the molding as claimed in claim 1, wherein the filler material is thermally stable up to 200°C and neither hydrolyzable nor

2030200-3524001

hygroscopic, and is composed of inorganic or organic material.

5. The decorative sheet or the molding as claimed in
5 claim 1, wherein the particle size of the filler
material is in the range from 1 to 250 μm , in
particular from 5 to 50 μm .

10. The decorative sheet or the molding as claimed in
10 claim 1, wherein the filler material is selected from
the group consisting of inorganic materials
encompassing, inter alia, talc, chalk, dolomite,
aluminum hydroxide, magnesium hydroxide, barium
sulfate, pearlite, diatomite, mica, calcium
15 carbonate, and mixtures of these.

20. The decorative sheet or the molding as claimed in
20 claim 1, wherein the filler material is composed of
organic materials, such as ground residues of HPL
sheets, sawdust produced from HPL sheets when the
sheets are cut, ground used HPL sheets, ground
residues of timber sawdust products, wood fibers,
cellulose fibers.

25. 8. The decorative sheet or the molding as claimed in
25 claim 1, wherein the water content of the core layer
prior to press-molding to give a prepeg is from 0.5
to 10% by weight, in particular from 1.5 to 2.5% by
weight, based on the total weight of the core layer.

30. 9. The decorative sheet or the molding as claimed in
30 claim 1, wherein the water absorption of the sheet
decreases as the content of the filler material
rises, at a resin content of from 20 to 25% by
35 weight.

208020-3524003

10. The decorative sheet or the molding as claimed in
claim 9, wherein the volume swelling of the sheet
decreases as inorganic filler content rises, at a
resin content of from 20 to 25% by weight.

5

11. The decorative sheet or the molding as claimed in
claim 9, wherein the volume swelling of the sheet
remains almost constant as organic filler content
rises, at a resin content of from 20 to 25% by
10 weight.

10

12. The decorative sheet as claimed in claim 9, wherein
the flexural strength of the sheet with up to 50% by
weight content of filler material is at most 20%
15 lower than the flexural strength of a sheet in whose
core layer no filler material is present.

15

13. An article comprising the sheet or the molding of
claim 1 for external cladding of buildings in the
form of a curtain facade, of a panel screening a wall
or roof, or of cladding for a balcony, or of a
parapet panel or apron panel, or else for the
internal lining of walls or furniture, or of wet-
20 rooms or laboratory equipment.

25

14. A process for producing a sheet or a molding, in
which one or more mechanically precompacted layers
made from cellulose fibers, wood fibers, a mixture of
wood fibers and cellulose fibers, or from timber
30 sawdust products, enclosed by a hot-curing resin,
having been placed one upon the other, are press-
molded to one another and to one or more decorative
layer(s) in contact with one or both surfaces of the
combined layers, using heat, where the resin is
35 cured, which comprises, prior to the precompaction of

10012345678901020304050607080900

the layer(s) in a first step mixing filler material with the fibers or timber sawdust products or with the resin, and comprises, in a second step, admixing resin, fibers or timber sawdust products.

5

15. The process as claimed in claim 14, wherein, in the first step, cellulose fibers, wood fibers, a mixture of wood fibers and cellulose fibers, or timber sawdust products are mixed with the resin, and wherein filler material is admixed in a second step.

10

16. The process as claimed in claim 14, wherein the free water content of the mixture made from cellulose fibers, wood fibers, a mixture of wood fibers and cellulose fibers, or timber sawdust products, filler material, and resin is reduced to 0.5-10% by weight, in particular 1.5-2.5% by weight, based on the total weight of the mixture, by drying the mixture prior to the precompaction of the layers.

15

20. The process as claimed in claim 14, wherein the press-molding of the monilaterally or bilaterally with decorative layer(s) laminated combined layers is undertaken at a temperature of at least 120-180°C with a pressure of from equal/higher 65 to 100 bar.

25

20281020035227001